

Work Order ID 82353

March-29-12 2:31:46 PM

82353

Page 1

Item ID: D3770-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Tube

Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/29 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3770

Rev B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D37702-drill holes thru to finish size as per dwg D3770 Using DT94123- deburr

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

Handwritten notes and signatures:

- FF 12-04-17
- 4
- 12-4-17
- 12-4-17
- 12-4-17

W/O:		82353 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3770-3 PAR #: _____ Fault Category: Small PAB NCR: (Yes) No DQA: OK Date: 12/04/23
 Resolution: SCRAP Disposition: Scrap QA: N/C Closed: OK Date: 12/4/23

NCR:		12-1371 WORK ORDER NON-CONFORMANCE (NCR) 38.55						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/17	#100	Found at inspection that Qty x1 tube has a hole elongated and ovalized. P.C. operator error / Sig alignment	S 057042 12/04/17	Scrap + DASH AND Replan in 116720 Qty 1	FF 12/04/17	S 12/04/17	S 057042 12/04/17	S 12/04/17

NOTE: Date & initial all entries

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Page 2

March-29-12 2:31:46 PM

Item ID: D3770-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Tube

Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00				4X	✓		M-h 12/04/17
Quality Control									
140	Identify as per dwg & Stock Location: <u>250</u>	0.00							
140									
Packaging	Memo	0.00							40 12/4/18
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							12/4/19
Quality Control									

ME
12-04-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-29-12 2:31:50 PM

Page 1

Work Order ID: 82353

82353

Parent Item: D3770-3

D3770-3

Parent Item Name: Tube

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC
IPP Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased	No			100	f	83.2542	1.8125	7.631579			

M6061T6T1 000W065

6061T6 RD TUBE 1.00 x .065w

**

4 FF 12-04-17

Location

Loc Qty

Loc Code

MAT015

83.2542

114089

0.3114

116720

2

117983

80.9428

100.125
~~7.631579~~ 5.4375

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

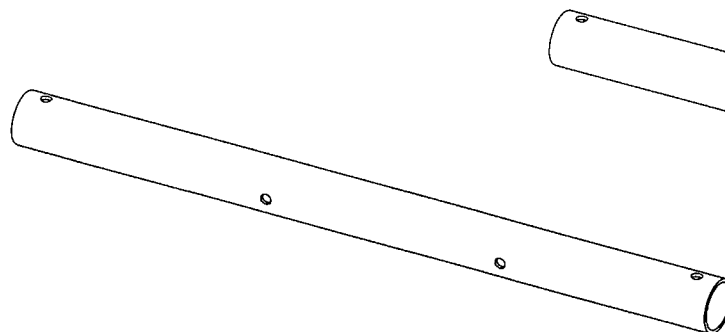
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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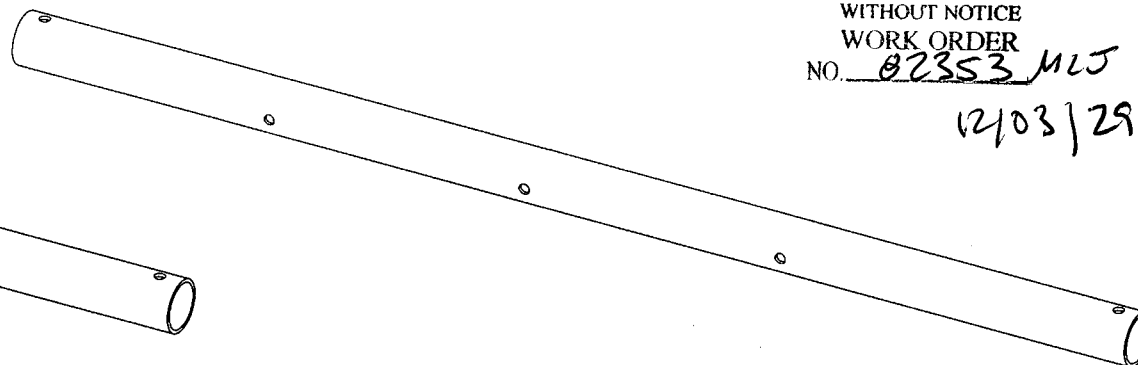
NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT

WITHOUT NOTICE
 WORK ORDER
 NO. 02353 MLJ
12/03/29



D3770-1 TUBE







D3770-3 TUBE

RELEASED
 11/08/07/10/14

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER VVV-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs
 D3770-3, 0.40 lbs

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		BY DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.23	DRAWING NO.	REV. B
		D3770	SHEET 1 OF 3
		TITLE	SCALE
		TUBE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

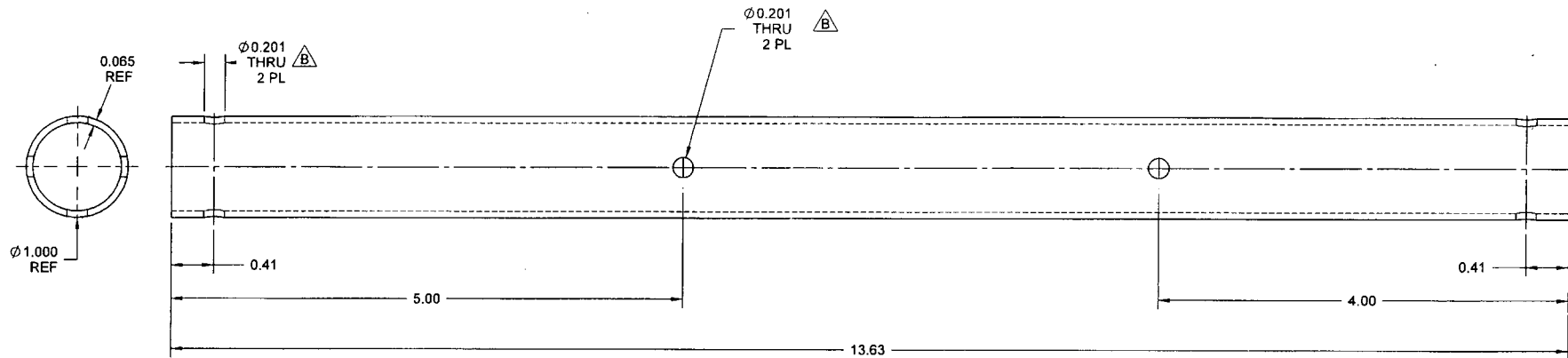
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

02353



D3770-1 TUBE

RELEASED
08.07.11

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3770	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		TUBE	NTS
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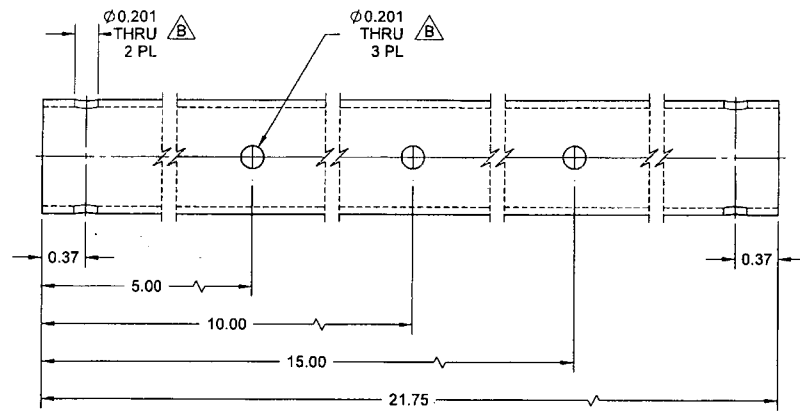
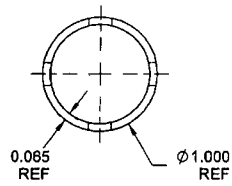
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

82353



D3770-3 TUBE

RELEASED
08.07.10/11

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. D3770	REV. B SHEET 3 OF 3
DRAWN	HS			
CHECKED	<i>HS</i>			
MFG. APPR.	<i>HS</i>			
APPROVED	<i>HS</i>			
DE APPR.	<i>HS</i>	TITLE TUBE	SCALE NTS	
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